

Work Order ID 72250

Wednesday, July 20, 2011 9:55:20 AM



Page 1

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 7/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CMR Date: 11-07-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4055	B

100		0.00							
-----	--	------	--	--	--	--	--	--	--



Purchasing

Memo

Purchasing

Issue P/O: 14532
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required

0.00

CL 11/07/20 (4)

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--



Packaging

Memo

Packaging

0.00

CL 11/08/18 (4)

120	QC6- Inspect dimensions to drawing	0.00							
-----	------------------------------------	------	--	--	--	--	--	--	--



QC

Memo

Quality Control

0.00

Sulad/75(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

4X Ø M-11/08/25

140

QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

N BL 11-8-25

150

Packaging
Packaging

Identify as per dwg & Stock Location: 35 119

0.00

Memo

0.00

P

(4X) SP 11-08-25

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25
CL1108/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 9:55:18 AM

Page 1

Work Order ID: 72250



Parent Item: D4055-5



Parent Item Name: Tank Upper Cut Out



Start Date: 7/20/2011

Required Date: 8/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-5P 		Purchased	No			110	Each	0.0000	1	4			
Tank Upper Cut Out												07/11/08/18	

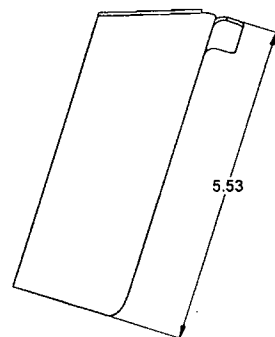
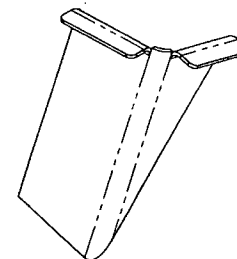
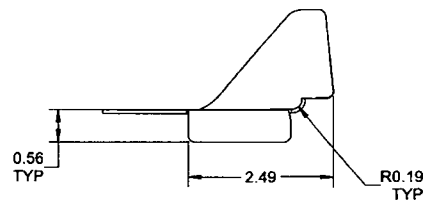
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NOTE: Date & initial all entries









D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
AN

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D4055	SHEET 8 OF 15
APPROVED			TITLE	SCALE
DE APPR.			TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

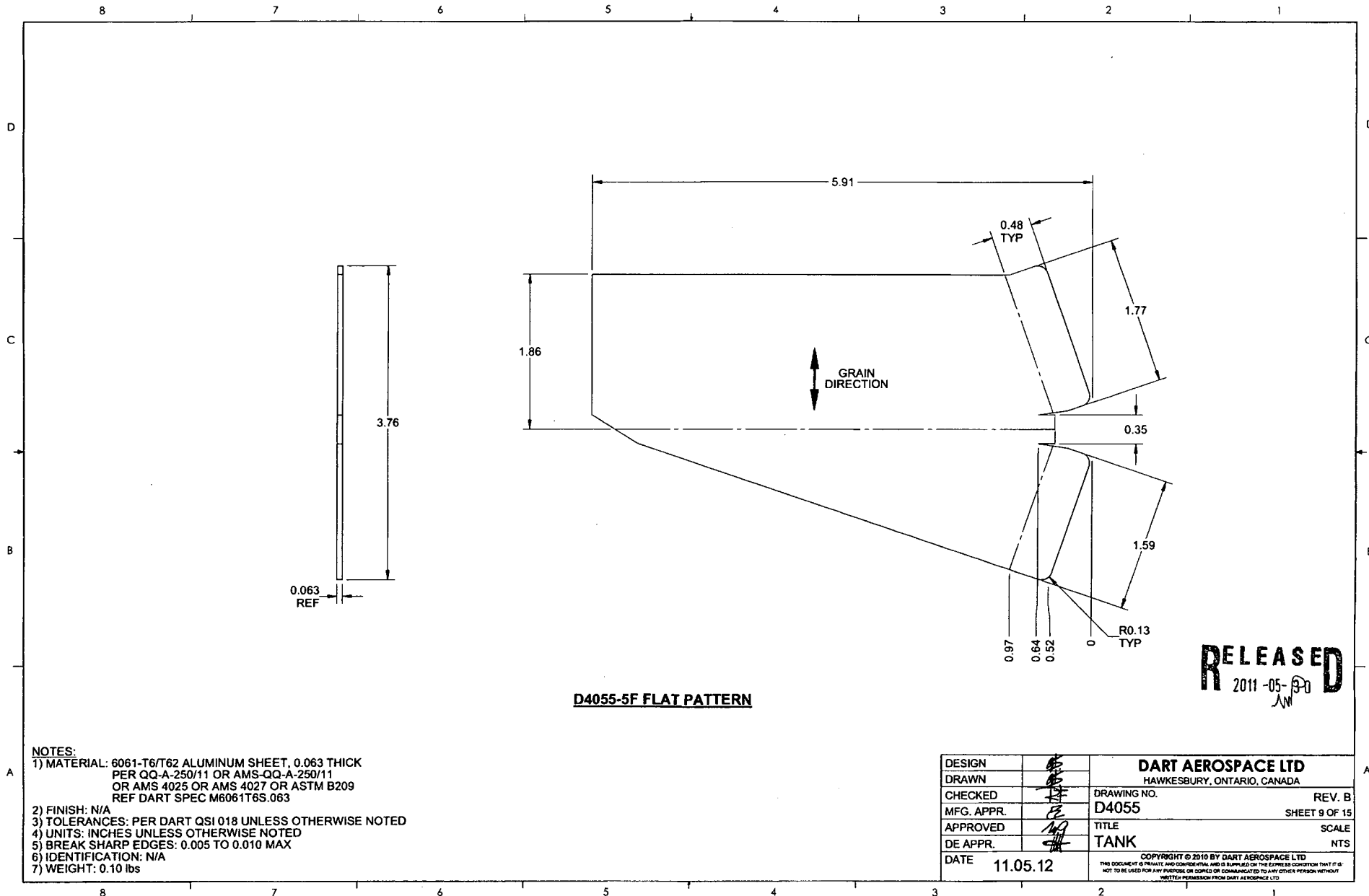
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TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

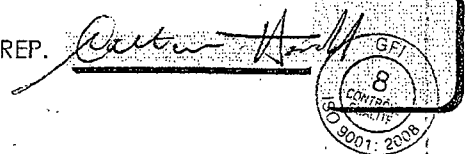
CERTIFICATE NO.	5	OUR JOB NO	J0234763	SHIPPING MEMO	0467725	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	4 PCS	PO14532	D4055-5P	B	TANK UPPER CUT OUT	B
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
.063 THK AL 6061-T6 (AMS-QQ-A-250/11)		SAMUEL / ALCOA INC		613714		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0234763-001 (4 PCS)		
3	AMENDED C OF C ON 24 AUGUST 2011		
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 15 AUGUST 2011

G.F.I. Q.C. REP.



LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: August 12, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 78920

Customer's order #:

de commande SSMQ: 552438
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	3	.0630" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	613714

Bien à vous,
Yours truly,



CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Malcolm Murphy
Director of Manufacturing Davenport Works

Tennor Thom
Quality Assurance Manager

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

1263222 Ship Date 2011-07-01
B.L. No. 6040526
Invoice No. 00000
Alcoa No. Item 1000291425-1
P.O. No./Govt Contract No. C63748 Ln#: 1
Customer SAMUEL SON & CO LT G041094947R05
Alcoa Item DCE-91425-1

Page 1 of 2

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 - .125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC_MRK
ASTMB209 REV 07 CMMPO25 REV S ((MARKED))
KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-
30 % CQR 0210640 REV 05 CUST REQ 11-06-
11 *** W/E 11-06-18 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	315871	613714	2326	57	PC	27107 27707 47004

Notes for CQR: 0210640.5
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0210640.5 -Specification Limits

Temp Dir	UTS	TYS	EL4D
T6 Long Transv.	KSI	KSI	PCT
Max			
Min	42.0	35.0	10

Chemical Composition

Alloy	Max	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
6061	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
Lot: 613714	Min	0.40	0.15	0.15	0.8	0.04					

Temp Dir	UTS	TYS	EL4D
T6 Long Transv.	KSI	KSI	PCT
No->			
Test	50.2	44.6	10.5
2	51.1	45.6	10.3

Sula/75

D923214

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

1263222
Ship Date

0
B.L. No.

Invoice No.

Alcoa No. Item

2011-07-01

6040526

00000

1000291425-1

P.O. No./Govt Contract No.

Customer

Alcoa Item

DCB-91425-1

C63748 Ln#: 1

SAMUEL SON & CO LT G041094947R05

Page 2 of 2

Lot: 613714
Cast Number
H9334105

- Mechanical, Physical, Metallography, Quantometer Results (cont.)
Chemical - OBS SI FE CU MN MG CR ZN TI
Actuals 0.65 0.4 0.25 0.07 1.0 0.16 0.06 0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States